

# Work Order ID 62118

Thursday, September 16, 2010 9:25:44 AM

Page 1

Item ID: PB67-43001-29

Accept

Setup Start

Revision ID:

Stop

Item Name: Blade Positioner Weldment

Start Date: 9/16/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 10-9-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

B67-43001

C

100

Weld per dwg A/R Aluminum rod Batch: M112860 0.00

Large Fab

Large Fab

Memo

0.00

\*\*\*\*FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG. MOVEMENT OF -285 EACH SIDE OF VERTICAL, PRIOR TO WELDING\*\*\*\*

1- ASSEMBLE AND WELD AS PER DWG

10.09.30 2 f

PTO

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

10.09.30  
10.10.01

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

10.10.01

42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-29 PAR #: \_\_\_\_\_ Fault Category: Lavey Fob NCR: Yes No DQA: ✓ Date: 10.10.08  
 Resolution: re-work Disposition: re-work QA: N/C Closed ✓ Date: 10/10/08

NCR: <u>62118</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.09.30	100	The PB67-43001-337 stop plates were welded flush to the PB67-43001-313 plate; no 0.818 gap. R.C. Lost to change details.	<u>OS/042</u> L20	Trim off the -337 & grind welds smooth & flush to the -319 gusset (to original dim). weld new -337 stops per dwg.	<u>OS/042</u> 10.10.01	<u>S</u> 10/10/01	<u>OS/042</u> L20	<u>1005-30</u>
			<u>OS/042</u> L20	ensure to review dwg prior to welding & record on Job Training Log	<u>OS/042</u> 10.10.01	<u>S</u> 10/10/01	<u>OS/042</u>	<u>1005-30</u>

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 1.00



Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Powdercoat

Powder Coating

Green Sandtex (Ref: 4.3, 5.8) per QSI005 4.3

0.00 *15/10-10-16*

Memo

0.00

START TIME: *2:05*

OVEN TEMPERATURE: *320°*

FINISH TIME: *2:35*

*2*

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

*10/10/17 SL (20)*

150



Packaging

Packaging

Identify as per dwg & Stock Location: *447*

0.00

Memo

0.00

*10/10/17 SL (20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 62118**

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Item ID: PB67-43001-29

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Revision ID:

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Item Name: Blade Positioner Weldment

Start Date: 9/16/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/08 *[Signature]*  
MF  
10-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 16, 2010 9:25:44 AM

Page 1

Work Order ID: 62118

Parent Item: PB67-43001-29

Parent Item Name: Blade Positioner Weldment




Start Date: 9/16/2010

Required Date: 9/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-27 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-313  Plate		Manufactured	No			100	Each	20.0000	1	1			
<div> <div>Location</div> <div>ST443A</div> <div>54672</div> </div> <div> <div>Loc Qty</div> <div>20</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
PB67-43001-319  Gusset		Manufactured	No			100	Each	13.0000	2	2			
<div> <div>Location</div> <div>ST439A</div> <div>44967</div> </div> <div> <div>Loc Qty</div> <div>13</div> <div>13</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
PB67-43001-337  Stop Plate		Manufactured	No			100	Each	15.0000	2	2			
<div> <div>Location</div> <div>ST439A</div> <div>44966</div> </div> <div> <div>Loc Qty</div> <div>15</div> <div>15</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

*Handwritten:* 10.09.22

*Handwritten:* 10.09.22

*Handwritten:* 10.09.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

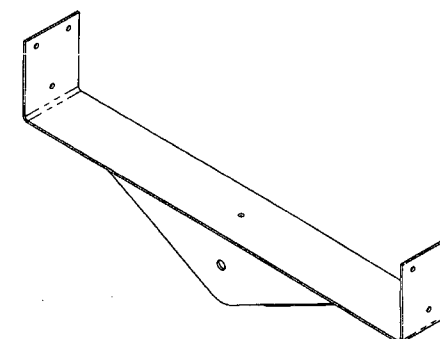
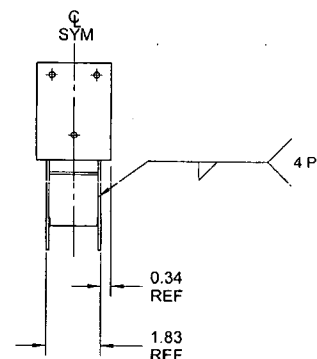
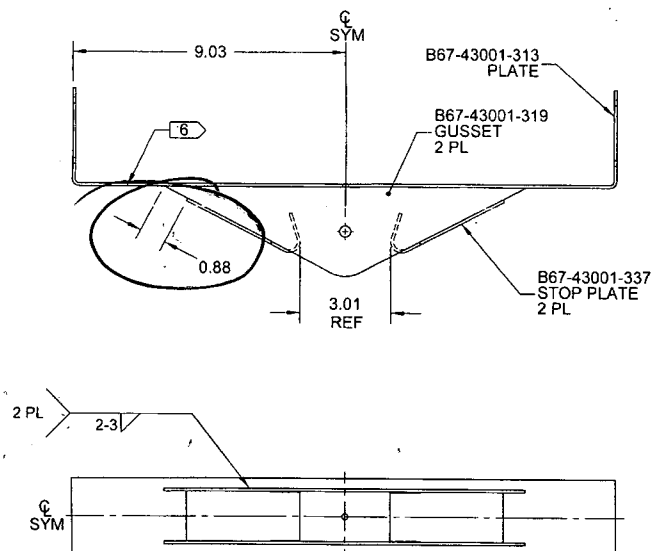
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



ITEM	QTY -29	P/N	DESCRIPTION
1	X	B67-43001-29	BLADE POSITIONER WELDMENT
3	1	B67-43001-313	PLATE
4	2	B67-43001-319	GUSSET
5	2	B67-43001-337	STOP PLATE



**B67-43001-29 BLADE POSITIONER WELDMENT**

#62118

**RELEASED**  
2009-09-24

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-29" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.01 lbs
- 8) WELDING: PER QSI 004

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 40 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.24
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	AS	DRAWING NO. B67-43001-29		REV. C
MFG. APPR.	AS	TITLE		SCALE
APPROVED	AS	BLADE POSITIONER WELDMENT		NTS
DE APPR.	N/A			
DATE	09.06.24	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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